

Date: Wednesday, 8/15/2007 7:53:09 AM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR FWD LH
Job Number : 33897	
Estimate Number : 11227	
P.O. Number : N/A	Part Number : D32811
This Issue : 8/15/2007 S.O. No. : N/A	Drawing Number : D3281 REV 8
Prsht Rev. : NG	Project Number : N/A
First Issue : N/A	Drawing Revision : 6
Previous Run : 30658	Material : N/A
Type : R&D THERMOFORMING	Due Date : 8/22/2007
Written By : <i>[Signature]</i>	Qty: 10 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev A 04.07.01 New issue KJ/JLM Est. Rev B. 07.16.2007 Thermoform in house DL	

**ENGINEERING
APPROVAL**

07/10/16

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

F6002 701

lexan black



Comment: Qty.: 4.3600 sf(s)/Unit Total : 43.6000 sf(s)
lexan black .125"

Material Batch # *M 103735*
M 105952.

2.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



x8

Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

DL 07/08/21
DL 07/10/25

3.0

THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 007

Dwg. Rev. *B*Folio Rev. *B*

DL 07/08/21
DL 07/10/25

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



DL 07/08/21
DL 07/10/25

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR FWD LH

Job Number: 33897

Part Number: D32811

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

X10 07/10/25

BB 07-10-05'

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

2) Check dimensions to ensure conformity to drawing tolerances.

X10 07/10/05 - PTO
X10 07/10/25

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

count
7/10/27 (10)
POSITIVE RECALL

8.0

PACKAGING 1

PACKAGING RESOURCE #1



ENGINEERING
APPROVAL 07.10.29



Comment: PACKAGING RESOURCE #1

07/11/09 (10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10
07/11/10

Job Completion



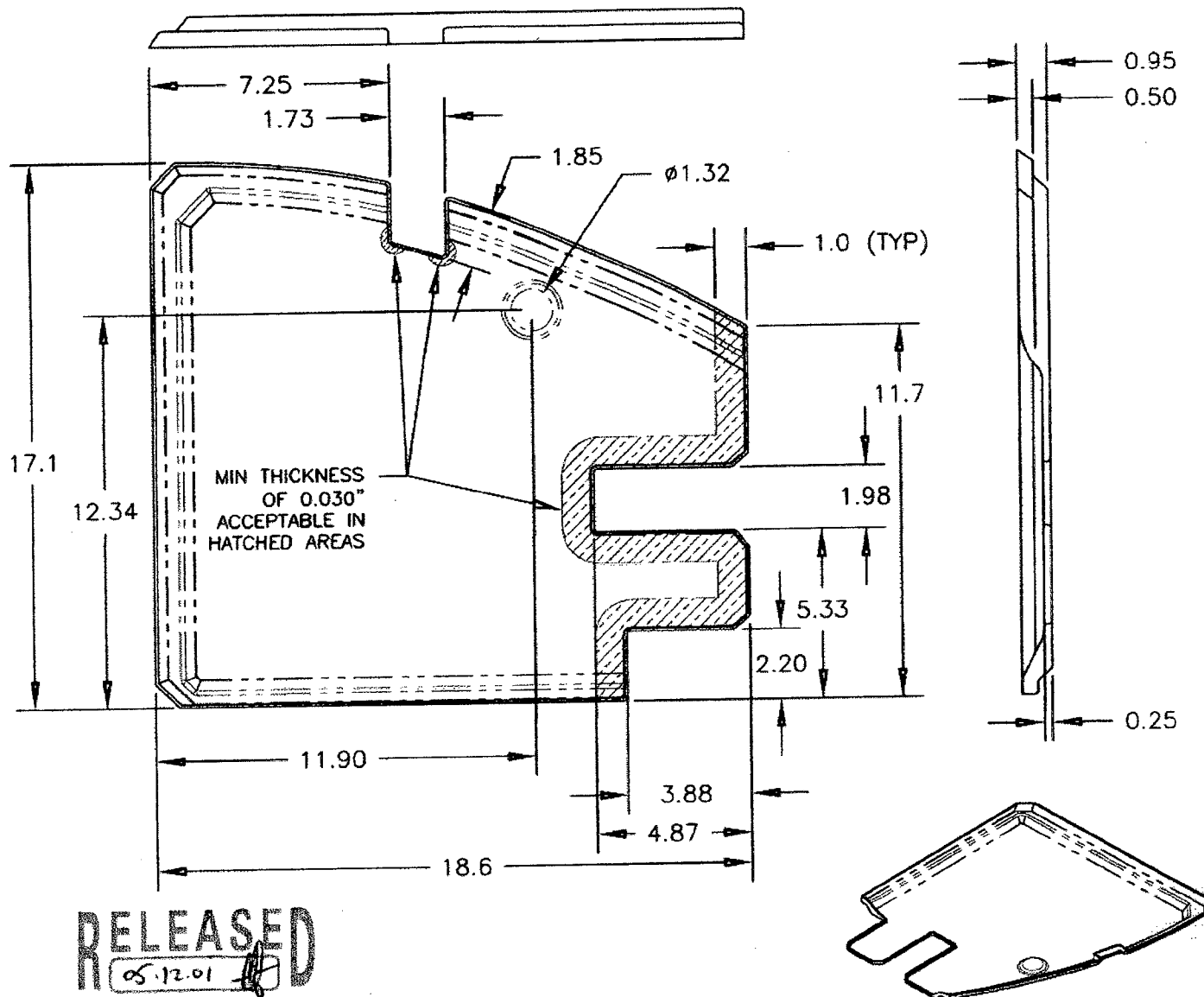
POSITIVE RECALL

EFFECTIVE 07/08/05 AUTH 11

RELEASED LE DATE 07.11.06



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. B
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	HL	APPROVED	HL	DRAWING NO. D3281	SHEET 1 OF 3
DATE	05.11.25	TITLE	FLOOR PROTECTOR	SCALE	1:5
A	04.05.03	NEW ISSUE			
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED			



RELEASED
05.12.01

D3281-1 FLOOR PROTECTOR, FWD LH

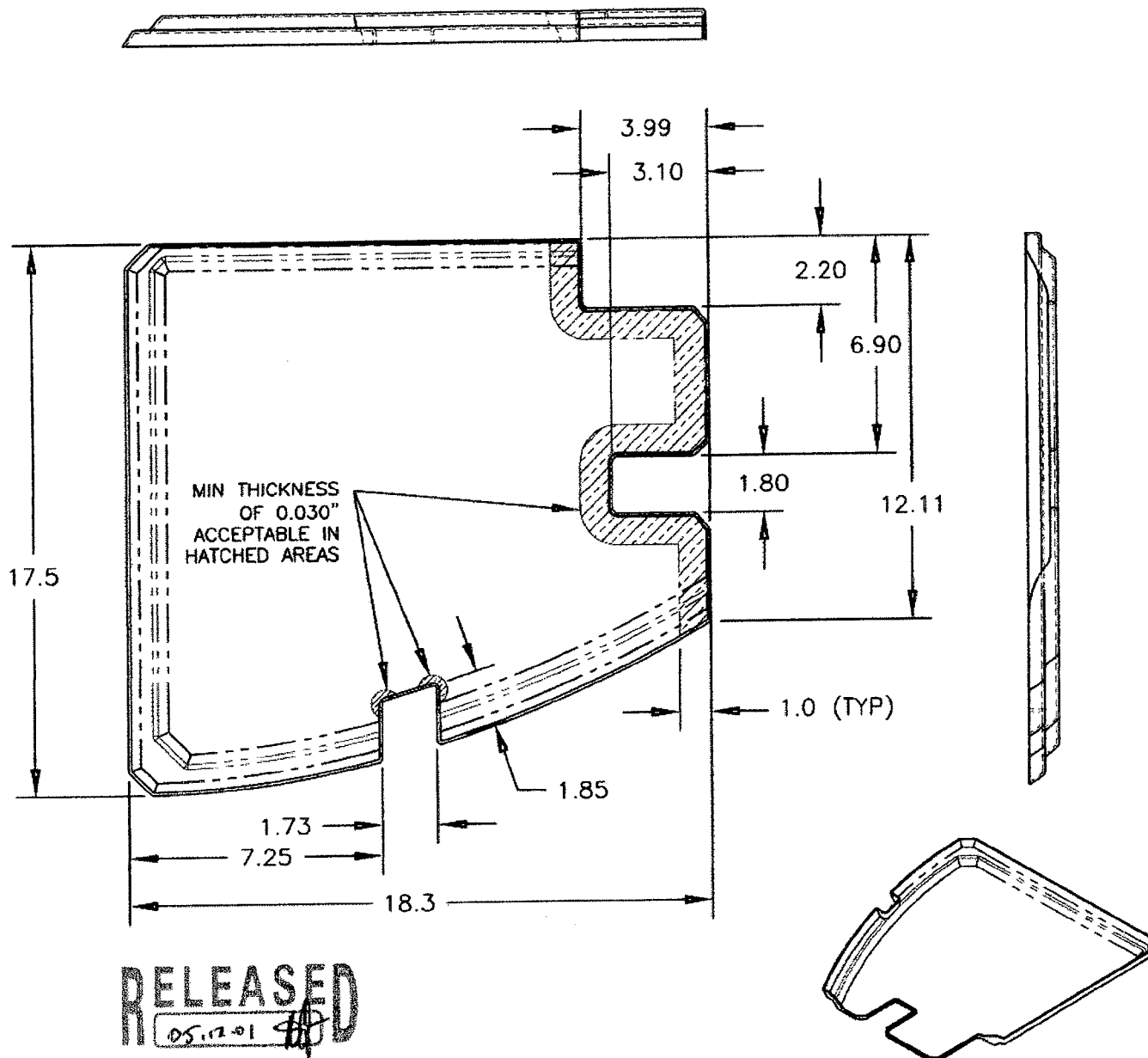
- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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CHECKED	APPROVED	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



D3281-2 FLOOR PROTECTOR, FWD RH

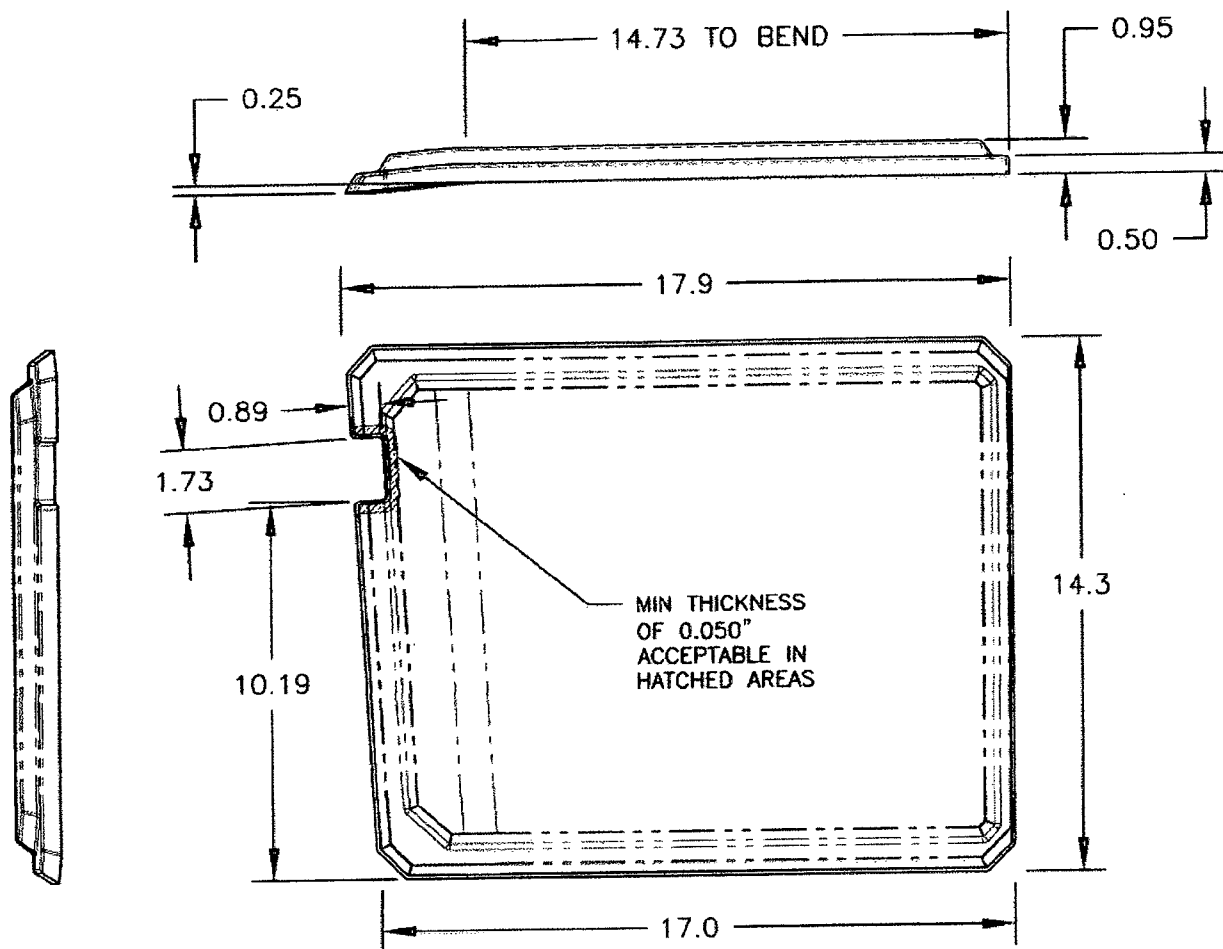
- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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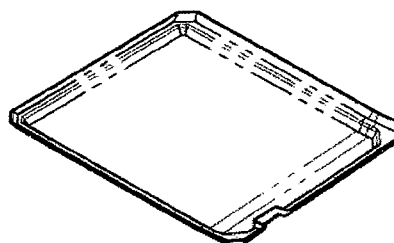
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CHECKED	APPROVED	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



RELEASED
05.12.01



D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)

D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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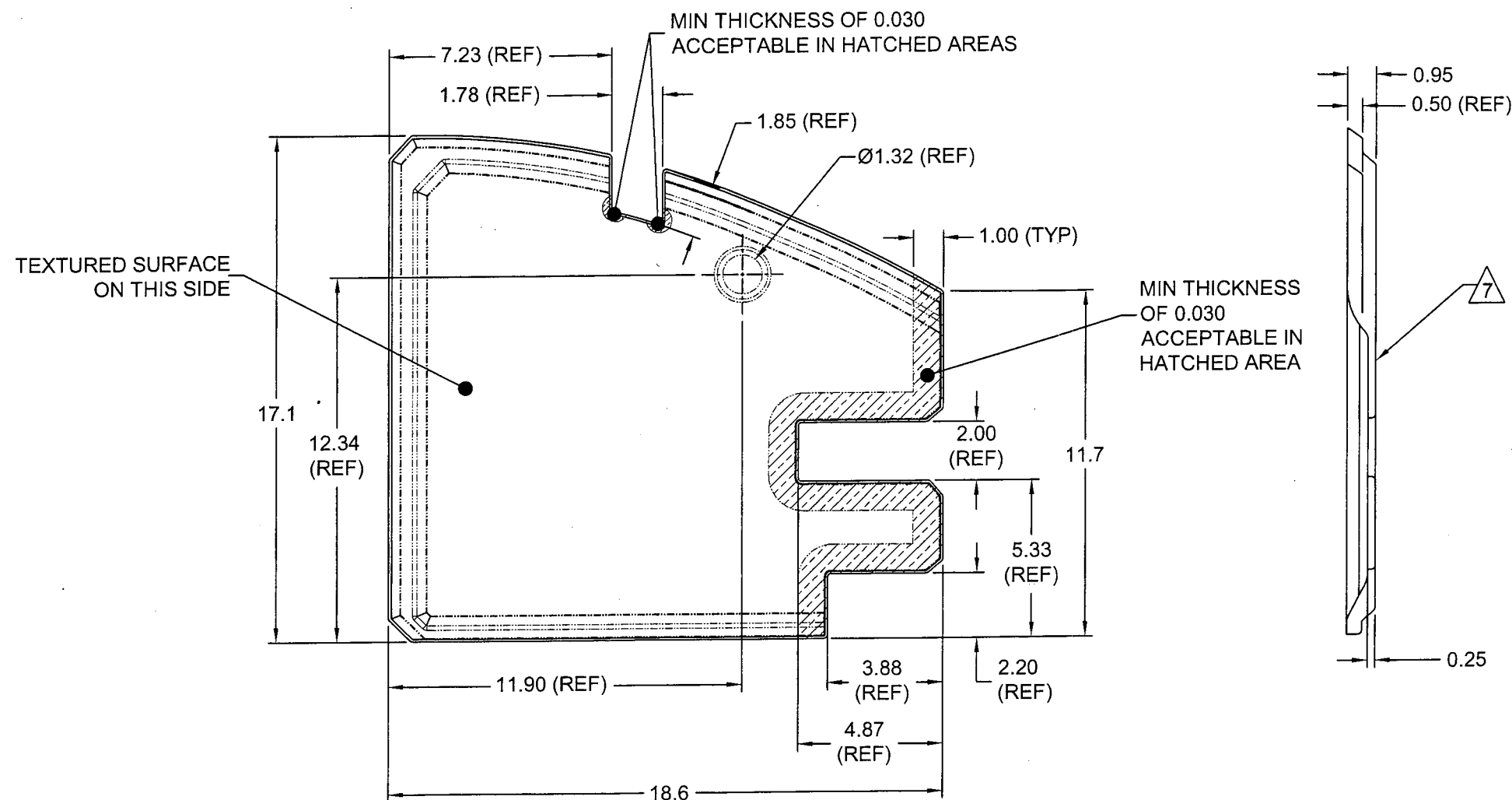
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D

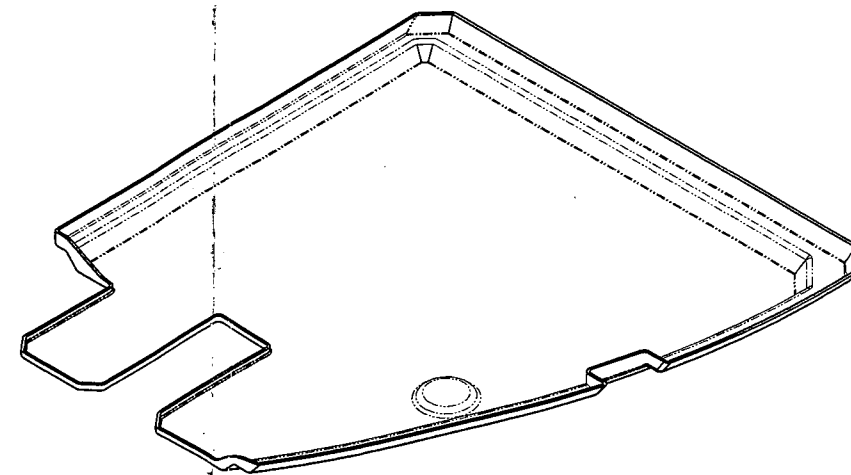
C

B

A

**D3281-1 FLOOR PROTECTOR****D3281-1 NOTES:**

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33897

PRELIMINARY ISSUE


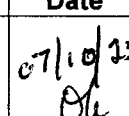

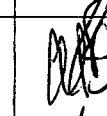
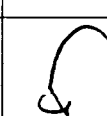
LE 07.10.09

C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	LE	D3281	SHEET 1 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.10.35	6	8 parts not formed enough - Material batch M103735	 07/11/05	8 parts scrap & replace.	 07/10/15 OK.	 07/11/05	 07/11/05	 07/14/29

NOTE: Date & initial all entries

DART AEROSPACE LTD		WORK ORDER: <u>33897</u>
Description: R44 Floor Protector Front LH		Part Number: D3281-1
Inspection Dwg: D3281	Rev: B	Page 1 of 1

C preliminary

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Inside Radii less than 3/16" go/no go	<i>[Signature]</i>
Acceptable shape definition	<i>[Signature]</i>
Acceptable texture retention	<i>[Signature]</i>
Free of visual flaws (bumps, cracks, voids, etc.)	<i>[Signature]</i>

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3281 Rev. ~~B~~ and record below *C preliminary*

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.6	.1	18.68	✓		TAPE	
17.1	.1	17.1	✓		TAPE	
11.7	.1	11.7	✓		TAPE	
.95	.030	.954	✓		CAL.	
.25	.030	.251	✓		CAL.	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval: <i>[Signature]</i>
Date: 07.10.25	Date: 07/10/25	Date: 07.10.29

Rev	Date	Change	Revised by	Approved
		New Issue		